

Date: Wednesday, 04/06/2008 8:31:00 AM
User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 03.250 SUPPORT
Job Number : 39685 - **B**
Estimate Number : 10387
P.O. Number :
This Issue : 04/06/2008 S.O. No. :
Prsht Rev. : NC Part Number : D29401
First Issue : 11 Type : MACHINED PARTS Drawing Number : D2940 REV B
Previous Run : 39390 Drawing Revision : B
Material :
Written By : Due Date : 27/06/2008 Qty: **10** Um: Each
Checked & Approved By : JULIE LECOCQ
Comment : Est. C 02.11.26 Reformat; Added P/O KJ
Est Rev:D Added priming as per Rev B 07-04-30 JLM
est E 08.03.19 Re-format Ec verified by DD

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DSK081 D2940-1 TURNING DETAIL



Comment: Qty.: 0.5000 Each(s)/Unit Total : 10.0000 Each(s)
D2940-1 TURNING DETAIL
Batch: **B 39685**

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS
1- Machine as per Folio FA079
2- Tumble & Deburr

J.L/H.A

08/08/02

3.0 QC1 INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

M.A

08/08/05

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

SB 08/08/05

5.0 POWDER COATING POWDER COATING



M 108523



(10x)

Comment: POWDER COATING
Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3
*****Mask Inside Surface as per Dwg D2940*****

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

9:15
400 °C
9:45

M.A

08/08/05

Wednesday, 04/06/2008 8:31:00 AM
Lecocq

Process Sheet

Order: CU-DAR001 Dart Helicopters Services

Drawing Name: 03.250 SUPPORT

Number: 39685

Part Number: D29401

Seq. #:

Machine Or Operation:

Description :

1.1

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

Prime inside surface as per Dwg D2940 and QSI 005 4.3.

ml 08 08 05

(10)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



0



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

25 08-08-06

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: LG

ml 08 08 06

(10)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

10 08/06/08

Job Completion



U 08.08.06

DART AEROSPACE LTD		Work Order: 39685
Description: Ø3.250 Support		Part Number: D2940-1
Inspection Dwg: D2940	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AB	0.490	0.510		0.500	0.500	0.500	0.500	0.500
AC	0.140	0.160		0.153	0.153	0.154	0.154	0.151
AD	3.510	3.530		3.518	3.518	3.518	3.518	3.518
AE	1.633	1.673		1.661	1.661	1.654	1.654	1.654
AF	1.493	1.513		1.510	1.510	1.504	1.503	1.503
AG	0.040	0.060		0.051	0.051	0.054	0.049	0.0515
AH	0.188	0.193		0.188	0.188	0.188	0.188	0.188
AI	0.140	0.160		0.152	0.153	0.151	0.149	0.150
AJ	2.518	2.538		2.525	2.525	2.528	2.528	2.523
AK	0.040	0.060		0.048	0.048	0.047	0.049	0.047
AL	0.010	0.020		0.012	0.012	0.012	0.012	0.012
AM	0.140	0.160		0.1495	0.149	0.153	0.155	0.151
AN	0.350	0.450		0.375	0.385	0.390	0.385	0.386
AO	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AP	0.150	0.170		0.154	0.151	0.1495	0.151	0.1505
AQ	0.053	0.073		0.060	0.060	0.060	0.060	0.063
AR	101.64	105.64		103.64	103.64	103.64	103.64	103.64
AS	0.260	0.267		0.260	0.260	0.260	0.260	0.260
AT	0.053	0.073		0.063	0.063	0.063	0.063	0.063
AU	4.118	4.138		4.128	4.129	4.128	4.128	4.128
AV								
AW								
Accept/Reject								

Measured by: M.A	Date: 08/08/02
Audited by: L.S	Date: 08/08/05
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM	
D	08.04.22	Reformat	KJ/JLM	

DART AEROSPACE LTD		Work Order: 39685
Description: Ø3.250 Support		Part Number: D2940-1
Inspection Dwg: D2940	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16	17	18	19	10
HAAS Section								
AA	0.240	0.260		0.250	.250	.250	.250	.250
AB	0.490	0.510		0.500	.500	.500	.500	.500
AC	0.140	0.160		0.151	.152	.152	.154	.154
AD	3.510	3.530		3.518	3.520	3.519	3.521	3.521
AE	1.633	1.673		1.655	1.643	1.648	1.660	1.662
AF	1.493	1.513		1.503	1.493	1.494	1.508	1.508
AG	0.040	0.060		0.0525	.048	.050	.048	.045
AH	0.188	0.193		0.188	.188	.188	.188	.188
AI	0.140	0.160		0.151	.149	.148	.159	.158
AJ	2.518	2.538		2.523	2.528	2.528	2.528	2.528
AK	0.040	0.060		0.047	.049	.051	.053	.048
AL	0.010	0.020		0.012	.015	.015	.015	.015
AM	0.140	0.160		0.153	.145	.143	.150	.147
AN	0.350	0.450		0.390	.380	.370	.397	.384
AO	0.240	0.260		0.250	.250	.250	.250	.250
AP	0.150	0.170		0.1525	.154	.154	.153	.154
AQ	0.053	0.073		0.060	.063	.063	.063	.063
AR	101.64	105.64		103.64	103.64	103.64	103.64	103.64
AS	0.260	0.267		0.260	.260	.260	.260	.260
AT	0.053	0.073		0.063	.063	.063	.063	.063
AU	4.118	4.138		4.123	4.126	4.130	4.128	4.128
AV								
AW								
Accept/Reject								

Measured by: MK	Date:
Audited by: SB	Date: 08/08/05
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
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